Page 1

July-11-12 12:44:51 PM *N900040100* Accept Item ID: D3838-042 Setup Start Revision ID: Stop Item Name: Rib Assembly (Basket Lid, RH) Start Otv: 1.00 Start Date: 7/11/12 Cust Item ID: Required Date: 7/11/12 Rea'd Otv: 1.00 **Customer:** Reference: Run Date:/2-07-10 Tooling: Process Plan: Date: Approvals: Stop SPC (Y/N): OC: Date: Date: Tool # Plan Reject Set Up/ **Tool ID** Accept Reject Insp. Sequence ID/ Operation Work Center ID Otv Oty Code Number Stamp Description **Run Hours** Draw Nbr **Revision Nbr** D3838 Rev A 0.00 ×3 13-07-22 MAL Large Fab *100* Large Fab 0.00 Memo Large Fab 1- cut D3838-2 and D3838-3 rib as per dwg D3838 2- remove identification markings

- 3- deburr
- 4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838 A/R ER316 S.S. Rod Batch: M / 22 357
- 5- c'sink hole as per dwg
- 6- grind weld flush where indicated on dwg D3838
- 7- weld D3759-1 bushing as per dwg D3838 A/R ER316 S.S. Rod Batch: M 122357
- 8- grind bushing weld flush as per dwg dwg D3838
- 9- deburr hole if necessary

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W/O:			WO	RK ORDER CHANG	ES				
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Work Order ID 87258 *87258* Page 2 July-11-12 12:44:51 PM Accept Item ID: D3838-042 *N900040100* Setup Start **Revision ID:** Stop Rib Assembly (Basket Lid, RH) Item Name: *1* Start Qty: 1.00 7/11/12 **Start Date: Cust Item ID:** Required Date: 7/11/12 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: Stop SPC (Y/N): Date: Date: QC:_ Reject Sequence ID/ Set Up/ **Tool ID** Reject Operation Tool # Plan Accept Insp. **Work Center ID** Qty Qty Number Code Stamp Description **Run Hours** 110 QC5- Inspect part completeness to step on W/O 0.00 3 501.33 *110* 0.00 Memo Quality Control QC9- Inspect visual per QSI004- Fusion Welds 0.00 120 N 13.07.23 3x *120* 0.00 QC Memo Quality Control 130 Identify as per dwg & Stock Location:_____ 0.00SH13.07.23 3,

0.00

Memo

130

Packaging

Packaging

Dart Aerospace Ltd

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Work Orde July-11-12 12:4		7258		*872	258*						Page 3
Revision ID:	D3838-042 Rib Assembl	y (Basket Lid, RH)		Accept	*N900	040	100)* s	Setup Start	171	S1* S2*
Start Date: Required Date: Reference:	7/11/12 7/11/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:	- -	I	Run Star Stop	I <i>N</i>	R1* R2*
Sequence ID/ Work Center II 140 *140* QC Quality Control)	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

B/ 1207,38

Dart Aerospace Ltd

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Page 1

Work Order ID:

87258

Parent Item:

D3838-042

Parent Item Name:

M304TS0.750W.065

304 SQ Tube .75x.75x.065W

Rib Assembly (Basket Lid, RH)

Purchased

No

Start Date: 7/11/12

Required Date: 7/11/12

Start Qty: 1.00

1.0317

Required Qty: 1.00

1.086

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Saq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Jssued	Status	
D3759-1 Bushing		Manufactured	No			100	Each	170.0000	1	1				
_	-212	(ZZ)1		Location		Loc Qty	Lo	c Code	*	3	12 -	<i>-</i> /> 7	2.1	4.
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				WA005		7								
				6648	9	1								
				8278	15	6								

100

M125513 X3.129'

<u>Location</u>	Loc Qty	Loc Code	2 (20)
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112398	0		
122051	1000		
MAT017	252.1169370		
120267	26.9468670		
120633	225.17007		
MAT018	41		<u> </u>
7636	41		

1,293.1169

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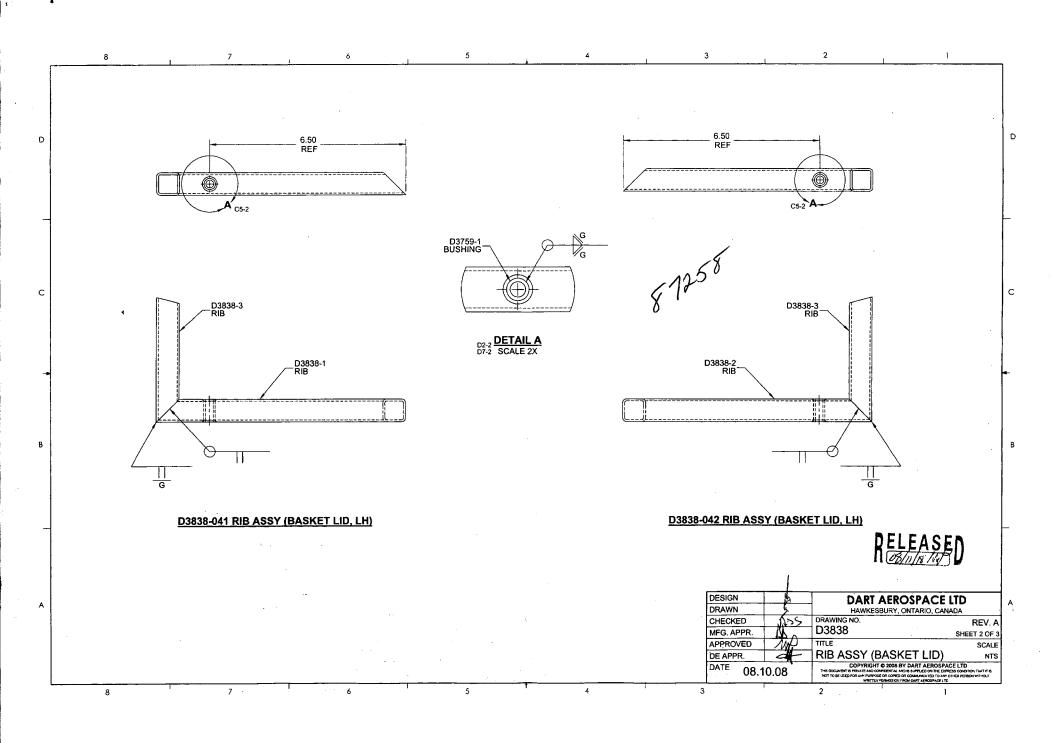
QTY -041 QTY -042 ITEM P/N DESCRIPTION D3838-041 RIB ASSY (BASKET LID, LH) RIB ASSY (BASKET LID, RH) 2 X D3838-042 BUSHING D3838-1 RIB D3838-2 RIB 1 D3838-3 RIB 8125812 D3838-041 RIB ASSY (BASKET LID, LH) D3838-042 RIB ASSY (BASKET LID, RH) NEW ISSUE 08.10.08 REV. DESCRIPTION BY DATE DESIGN **DART AEROSPACE LTD** DRAWN NOTES: 1) MATERIAL: N/A 2) FINISH: NONE HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A z) FINISH: NUNE
3) TOLERANCES: PER DART QSI:018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs D3838 MFG. APPR. SHEET 1 OF 3 TITLE APPROVED SCALE RIB ASSY (BASKET LID) NT.

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THE DOLLMENT BY NUMBER OLD MYCHINE, WAS BY DART OF THE DOMEST COMPONENT IN THE TOTAL OLD MYCHINE ON THE MYCHINE OWN PROMOTED COMMENTATION DOWN OF THE RESONNING OF THE MYCHINE OWN PROMOTED COMMENTATION DOWN OF THE RESONNING OF THE MYCHINE OWN PROMOTED COMMENTATION DOWN OF THE RESONNING OF THE MYCHINE OWN PROMOTED COMMENTATION DOWN OF THE RESONNING OF THE MYCHINE OWN PROMOTED COMMENTATION DOWN OF THE MYCHINE OWN PROMOTED COMMENTATION OWN PRO DE APPR. DATE 08.10.08

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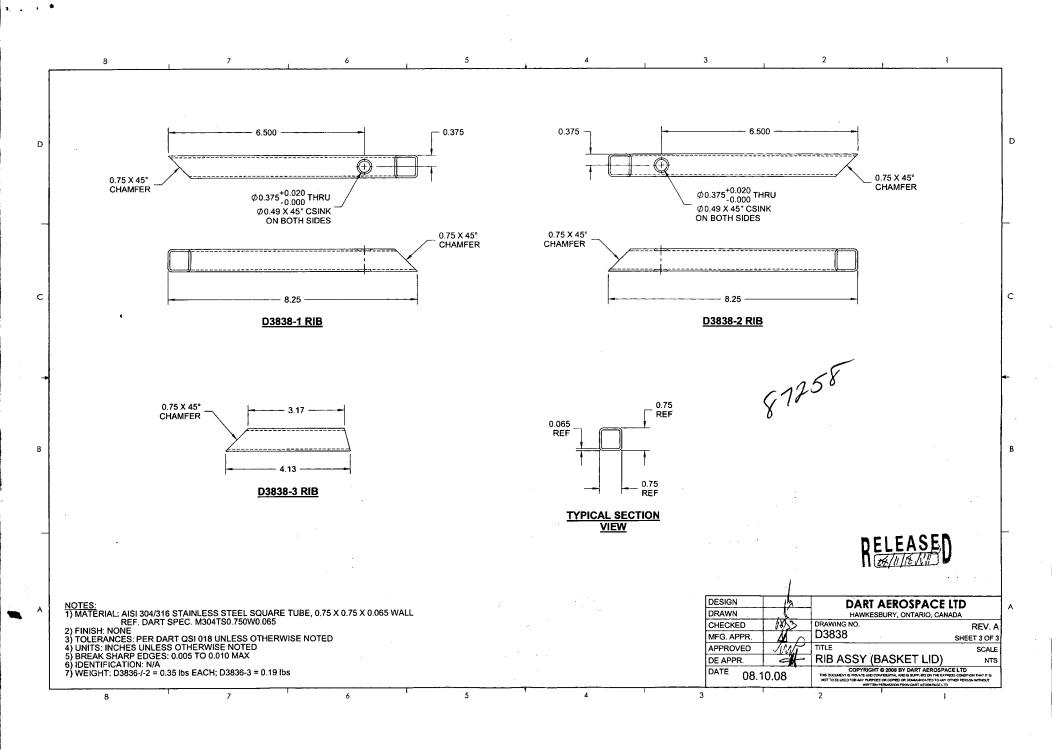
FAULT CATEGORY Landing Gear General Bending Bend Grain Pressure/Forced Ovalized Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Maintenance Part Moved Contamination Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Material
Setup
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Process
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